

Priority, 5/25/2007 8:37:41 AM

Johnston

Process Sheet

Split
SP 07/06/05

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32661
 Estimate Number : 12811
 P.O. Number :
 This Issue : 5/25/2007 S.O. No. :
 Prsht Rev : NC
 First Issue : 1/1 Type : SMALL/MED FAB
 Previous Run : 32003
 Written By :
 Checked & Approved By :
 Comment : Est Rev A New Issue 07-03.26 ec

Drawing Name : BRACKET
 Part Number : D35921
 Drawing Number : D3592 REVA
 Project Number : N/A
 Drawing Revision : REVA
 Material :
 Due Date : 6/10/2007

UNDER REVIEW

07-06-04
 OK 07/06/05
 Qty: 125 Um: Each

20

Additional Product

Job Number



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S125

6061-T6 .125 Sheet



Comment: Qty.: 0.1460 sf(s)/Unit Total: 17.5140 sf(s)

6061-T6 .125 Sheet

Batch: M104366

M104366

Grain must be Along 4.63

ml 070530

ml 070604

125

125

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3592

Dwg Rev: #

Prog Rev: #

2-Deburr if necessary

ml 070604

ml 070530

125

125

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

ml 070604
ml 070530

125



125

P10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS

07/06/05

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3592 using DT8949

SB

07/06/06

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/05	5	Split w/o	SB	07/06/05	30		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Number: 32661

Part Number: D35921

Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2006-06-20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W.A. (steps)

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

07.06.05

DATE

2006-06-20

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.06.07

Job Completion



07.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

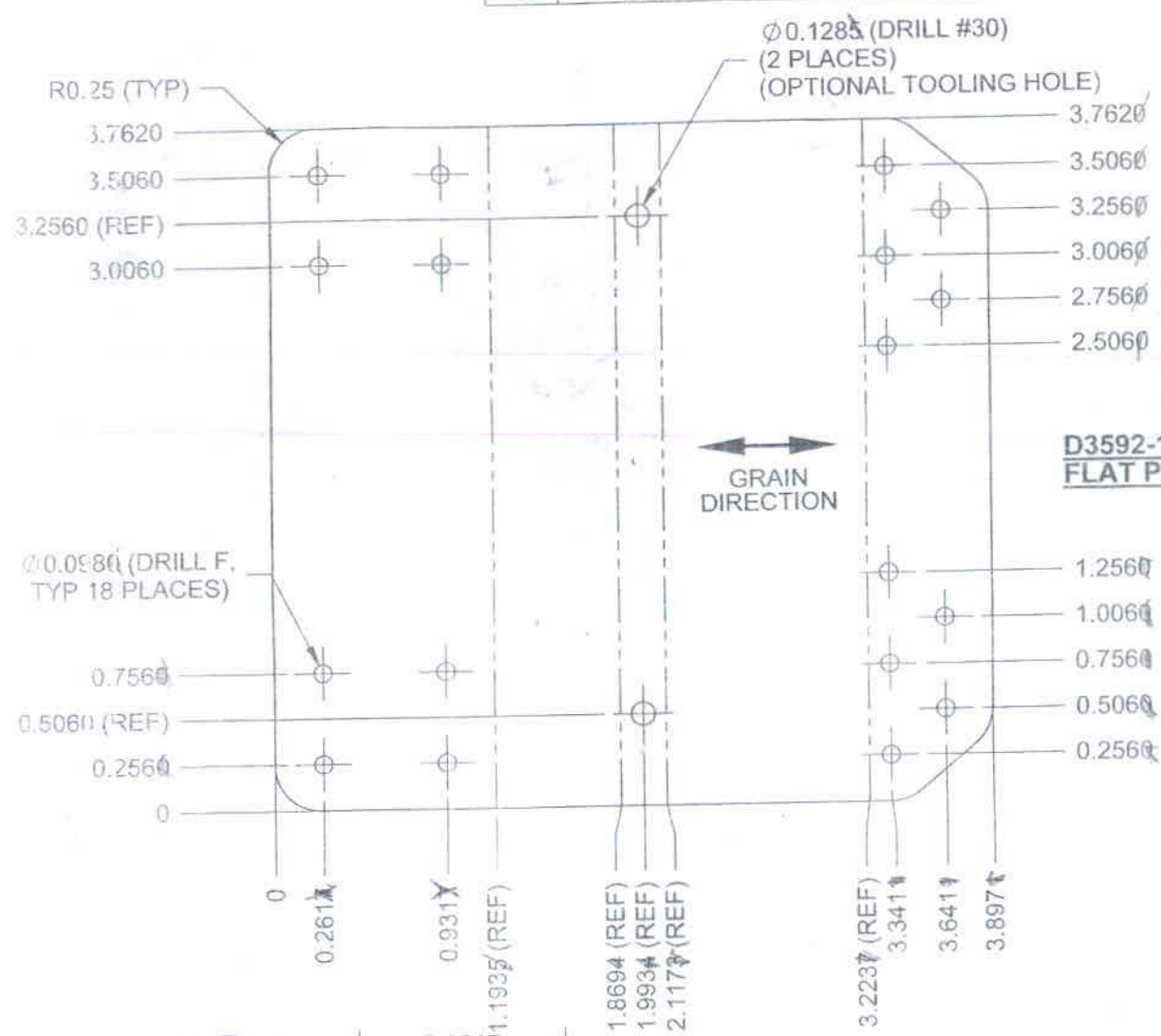
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

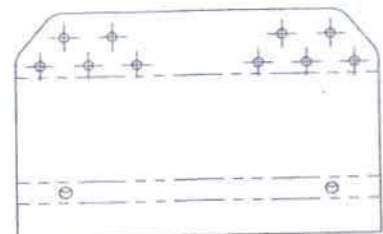
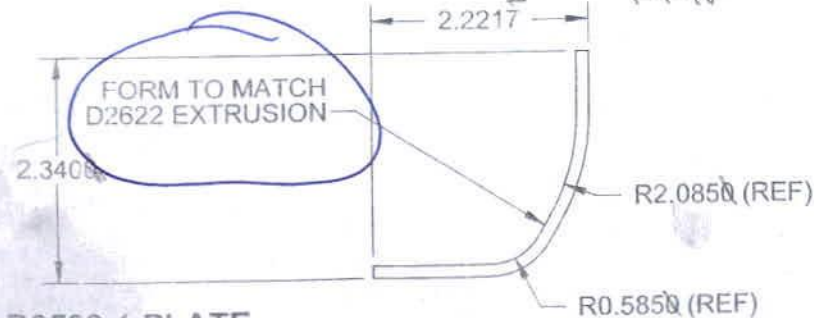
NOTE: Date & initial all entries

PRELIMINARY ISSUE
 07.06.04

DESIGN 90	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3592	REV. A SHEET 1 OF 1
DATE 07.01.15	TITLE PLATE		
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	



**D3592-1F
FLAT PATTERN**



**BEND DETAIL
SCALE 1:2**

D3592-1 PLATE

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 MAX

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AEROSPACE LTD

Work Order: 32661

Bracket

Part Number: D3592-1

Inspect for Dwg: D3592 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.128	+0.005-0.001	0.129	✓		VERN	
20.098	+0.004-0.001	0.099	✓		VERN	
0.506	+/-0.010	0.510	✓		VERN	
0.256	+/-0.010	0.260	✓		VERN	
0.756	+/-0.010	0.760	✓		VERN	
0.56	+/-0.010	3.260	✓		VERN	
	+/-0.010	0.265	✓		VERN	
	+/-0.010	1.995	✓		VERN	
	+/-0.010	3.346	✓		VERN	
	0.10	3.645	✓		VERN	
		3.902	✓		VERN	
		0.766	✓		VERN	

Seq

Co

20 W

Comment: FLOW

1-Cut a

Dwg Rev

Prog Rev

2-Deburr if ne

30

QC2



Comment: INSPECT PARTS AS

40

QC8



Comment: SECOND CHECK

50

SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOUR

Prototype Approval: N/A

Date: N/A

Revised by Approved

KJ/R

Form as per Dwg D3592 using DT894

W/O:		WORK ORDER CHANGES					Approval		App	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Chief Eng / Prod Mgr	QC Insp			
07.06.05	2	REPROGRAM TO REV.B TO ADD TOLLING HOLES. SEE ATTACHED DS EMAIL FOR OK ON TOLLING HOLES				<i>[Signature]</i> 07.06.05				
07.06.05	5	Split w/o								
07.06.12	5	Split w/o	SK SP	07.06.05 07.06.12	85 42	<i>[Signature]</i> 07.06.12	<i>[Signature]</i> 07.06.12			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.06.04	2.0	125 parts scrap. Parts needed extra holes for the bending tool.	<i>[Signature]</i> 07.06.04 P.V.	Scrap parts, and replace to Rev. B, under Preliminary Issue. See E-mail	<i>[Signature]</i> 07.06.04	<i>[Signature]</i> 07.06.03	<i>[Signature]</i> 07.06.04 P.V.	<i>[Signature]</i> 07.06.04
			Q51042	Scrap: destroy parts	<i>[Signature]</i> 07.06.04	SP 07.06.04	Q51042	

NOTE: Date & initial all entries

